

Work Order ID 68364

Tuesday, April 12, 2011 10:12:59 AM



Page 1

| | | | | | | |
|----------------|--------------|------------|------|-------|---------------|--|
| Item ID: | D3414-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Lug Assembly | | | | | |
| Start Date: | 4/12/2011 | Start Qty: | 6.00 | | Cust Item ID: | |
| Required Date: | 4/15/2011 | Req'd Qty: | 6.00 | | Customer: | |

Reference:

| | | | | | | | | | | | |
|------------|---------------|--|-------|----------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | | Date: | 11-04-12 | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3414 | Rev C | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| | Waterjet | | | | | | | | |
| FLOW CNC Waterjet | | | | | | | | | |
| 304 . 100 | | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | 1-Cut as per Dwg D3414-1 | | | | | | | | |
| | Dwg Rev: <u>C</u> | | | | | | | | |
| | Prog Rev: <u>C</u> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | | 0.00 | | | | | | | |
| | QC2- Inspect parts off machine FAI/FAIB | | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |

B11-4-20

(15)

B11-4-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 68364

Tuesday, April 12, 2011 10:12:59 AM



Page 2

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 4/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|-------------|--------------|---------------|---------------|------------------|----------------|
| 120 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | 8,11/04/20 | | (X15) | | | |
| 130 Brake NC Brake NC | Memo 1-Debur 2-Form using DT8254 as per Dwg D3414 | 0.00 0.00 | | SP 11/04/25 | | (15) | | | |
| 140 Large Fab Large Fab | Memo 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: M707051 | 0.00 0.00 | | | | EL 11-4-25 | | | (X15) |

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NOTE: Date & initial all entries

Work Order ID 68364

Tuesday, April 12, 2011 10:12:59 AM



Page 3

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 4/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

CPL 11-04-07

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

J. W. 11-04-27

(45)

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M116964

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:20
400°
7:50

15 BR 11-4-28.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 4

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| Revision ID: | | | | | Stop | |
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| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | QC3- Inspect Part Finish | 0.00 | | | | 15 | 0 | 44104/28 | |
| QC Quality Control | Memo | 0.00 | | | | | | | |
| 190 | Identify as per dwg & Stock Location 473 | 0.00 | | | | | | | |
| Packaging Packaging | Memo | 0.00 | | | | | | | |
| 200 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | |

MF
11-04-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:13:06 AM

Page 1

Work Order ID: 68364

Parent Item: D3414-041

Parent Item Name: Lug Assembly




Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 6.00


Required Qty: 6.00

Comments: IPP A 05.09.13 New issue KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S12GA  304/316 0.100" Sheet | | Purchased | No | | | 100 | sf | 156.0000 | 0.155 | 0.93 | | 2.4 | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT019 | 156 | |
| 113062 | 124 | |
| 113077 | 32 | |

113062

| | | | | | | | | | | | | | |
|---|--|--------------|----|--|--|-----|------|---------|---|---|--|---------|--|
| D3414-3  Lug | | Manufactured | No | | | 140 | Each | 17.0000 | 1 | 6 | | 11-4-25 | |
|---|--|--------------|----|--|--|-----|------|---------|---|---|--|---------|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA030 | 17 | |
| 66944 | 17 | |

15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 68364 |
| Description: Lug Bracket | | Part Number: | D3414-1 |
| Inspection Dwg: D3414 Rev: C | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.313 | +0.006/-0.001 | .315 | ✓ | | V VB02 | |
| 1.19 | +/-0.030 | 1.185 | ✓ | | V | |
| 1.00 | +/-0.030 | 1.008 | ✓ | | V | |
| 3.38 | +/-0.030 | 3.376 | ✓ | | V | |
| 5.350 | +/-0.010 | 5.352 | ✓ | | V | |
| 6.23 | +/-0.030 | 6.221 | ✓ | | V | |
| 2.500 | +/-0.010 | 2.501 | ✓ | | V | |
| 0.37 | +/-0.030 | .374 | ✓ | | V | |
| 0.100 | +/-0.010 | .103 | ✓ | | V | |
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|-----------------------|----------------------|----------------------------|-----|
| Measured by: B | Audited by: S | Prototype Approval: | N/A |
| Date: 11-4-20 | Date: 11/4/20 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 08.02.28 | New Issue P/O D3414-041 | KJ/DD | |
| B | 09.05.27 | Dimensions updated per Dwg Rev B | KJ | |
| C | 09.10.16 | Dwg Rev updated to Rev C | KJ | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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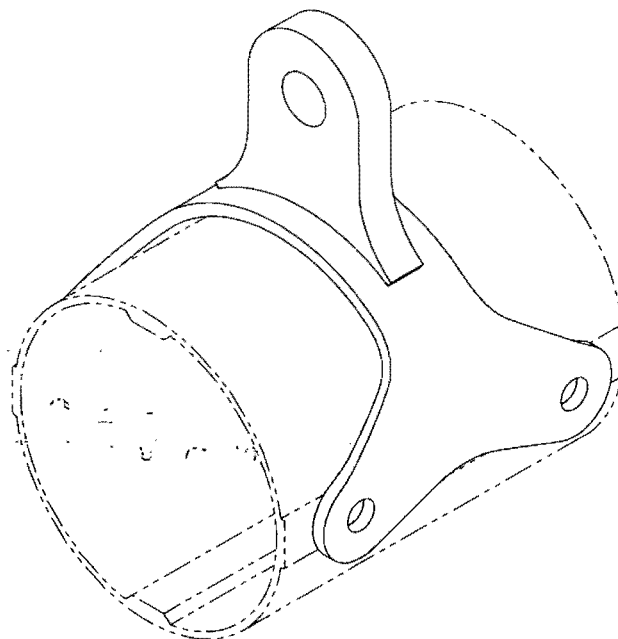
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM No. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|-----------|-------------|--------------|
| 1 | X | D3414-041 | LUG ASSEMBLY |
| 2 | 1 | D3414-1 | LUG BRACKET |
| 3 | 1 | D3414-3 | LUG |



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68364

2/11-04-12

RELEASED
8/16/05

| | | | |
|------------|---|--|--------------|
| C | BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3) | CP | 09.06.17 |
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR188). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20. | AJS | 08.09.23 |
| A | NEW ISSUE | CP | 05.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D3414 | SHEET 1 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | LUG ASSEMBLY | NTS |
| DATE | 09.06.17 | COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

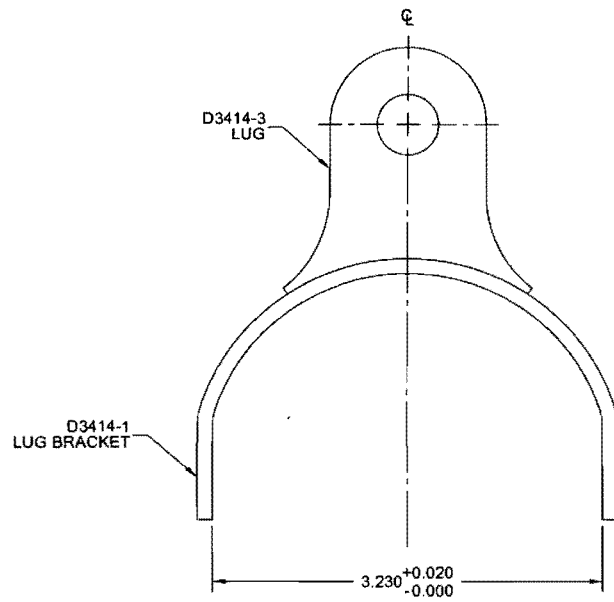
| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

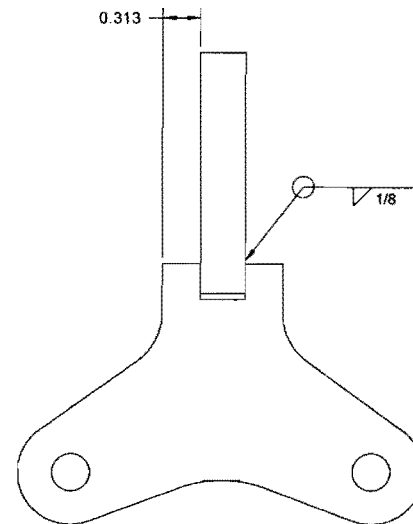
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NOTE: Date & initial all entries



D3414-041 LUG ASSEMBLY



w/o 68364

RELEASED

| | | | |
|------------|----------|--|--------------|
| DESIGN | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3414 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LUG ASSEMBLY | NTS |
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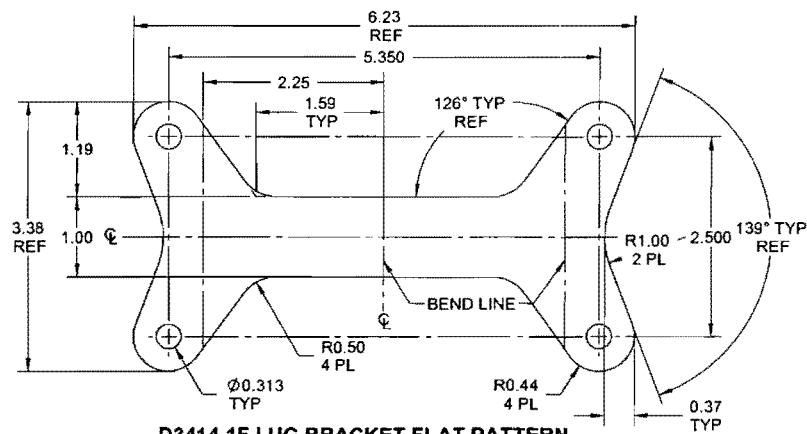
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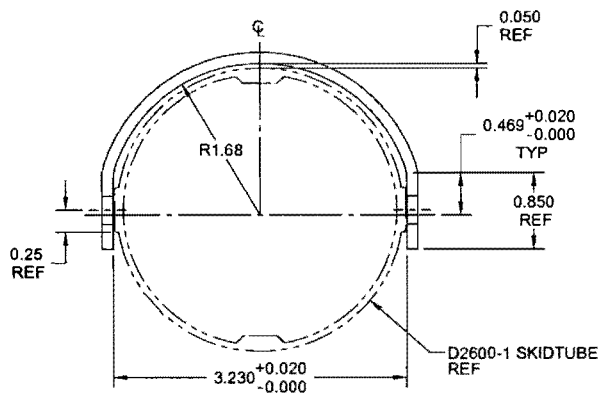
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| | | | | | | | | |

NOTE: Date & initial all entries



D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

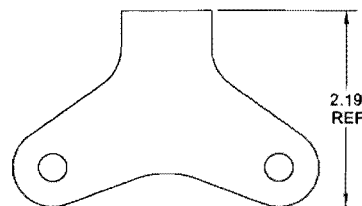
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX \triangle

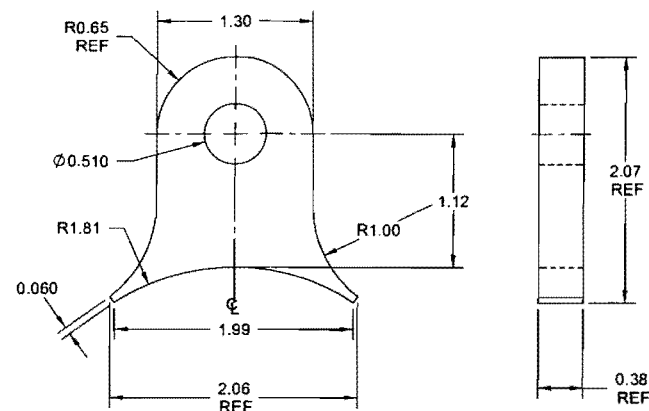
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY



D3414-3 LUG

RELEASED
29/06/06

| | | | |
|------------|----------|---|--------|
| DESIGN | OP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | OP | | |
| CHECKED | OP | DRAWING NO. D3414 | REV. C |
| MFG. APPR. | OP | SHEET 3 OF 3 | |
| APPROVED | OP | TITLE | SCALE |
| DE APPR. | OP | LUG ASSEMBLY | NTS |
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